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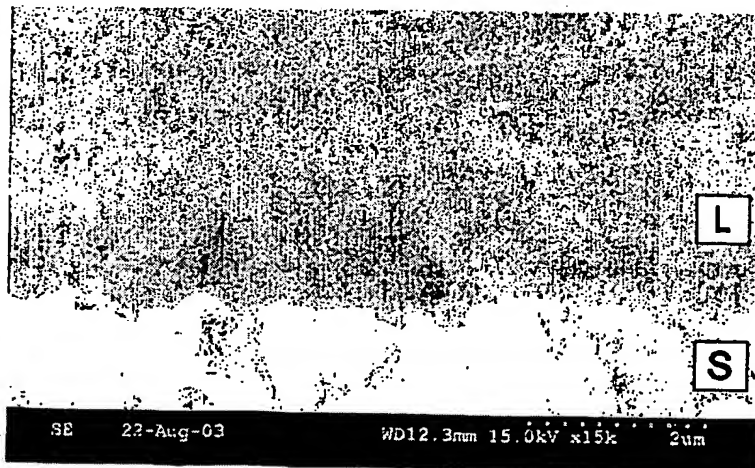
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(54) Title: PVD-COATED CUTTING TOOL INSERT



(57) Abstract: The present invention relates to a coated cutting tool insert of cemented carbide with a coating including at least one layer of $Ti_{1-x}Al_xN$ deposited by PVD-tech- nique. The layer has $x=0.4-0.6$ with a compressive residual stress of $>4-6$ GPa and a thickness of $1.5-5$, preferably $2.5-4$ μm . Both the $I(111)$ and $I(200)$ are <7.5 , preferably <5 , times, the intensity average noise level. Good adhesion despite high compressive stress is obtained if the layer is deposited by cathodic arc evaporation technique at a bias in the range $-90 < U < -50V$, preferably $-80V < U < -60V$.

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